

Date:
User:Wednesday, 6/6/2007 1:48:05 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GAS SPRING
 Job Number : 32774
 Estimate Number : 10336
 P.O. Number : N/A Part Number : D2807
 This Issue : 6/6/2007 S.O. No. : N/A Drawing Number : D2807 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : C
 Previous Run : 29827 Material : N/A
 Due Date : 6/25/2007 Qty: 50 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: D0506.21 Removed painting, Changed supplier
 KJ/JLM

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description:

1.0

PG

PURCHASING

Comment: PURCHASING

Issue P/O: 3926

Order as per Dwg D2807

Possible supplier: ArvinMeritor Motion Control Systems

Material release note is required

2.0

SXF6S6050080S6L115N

GAS SPRING

Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

SUPPORT PROP

3.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0

QC6

DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK

5.0

D28073

Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

2 D2807-3 Lug Batch: B 29831

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|--------------------|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 07/03/24 | 6 | Split u/o | SB | 07/03/24 | 5 | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Wednesday, 6/6/2007 1:48:06 PM
Jim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 32774

Part Number: D2807

Job Number



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Install lugs and crimp using DT8791 crimp jig.
2-Remove lettering and logo with wash and wipe.

FF 07-08-10
FF 07-11-21

45
5

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/11/22

(5)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 5748

FINAL INSPECTION/W/O RELEASE

LC 7/11/22 (5)

9.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

SB 07/11/22 (5)

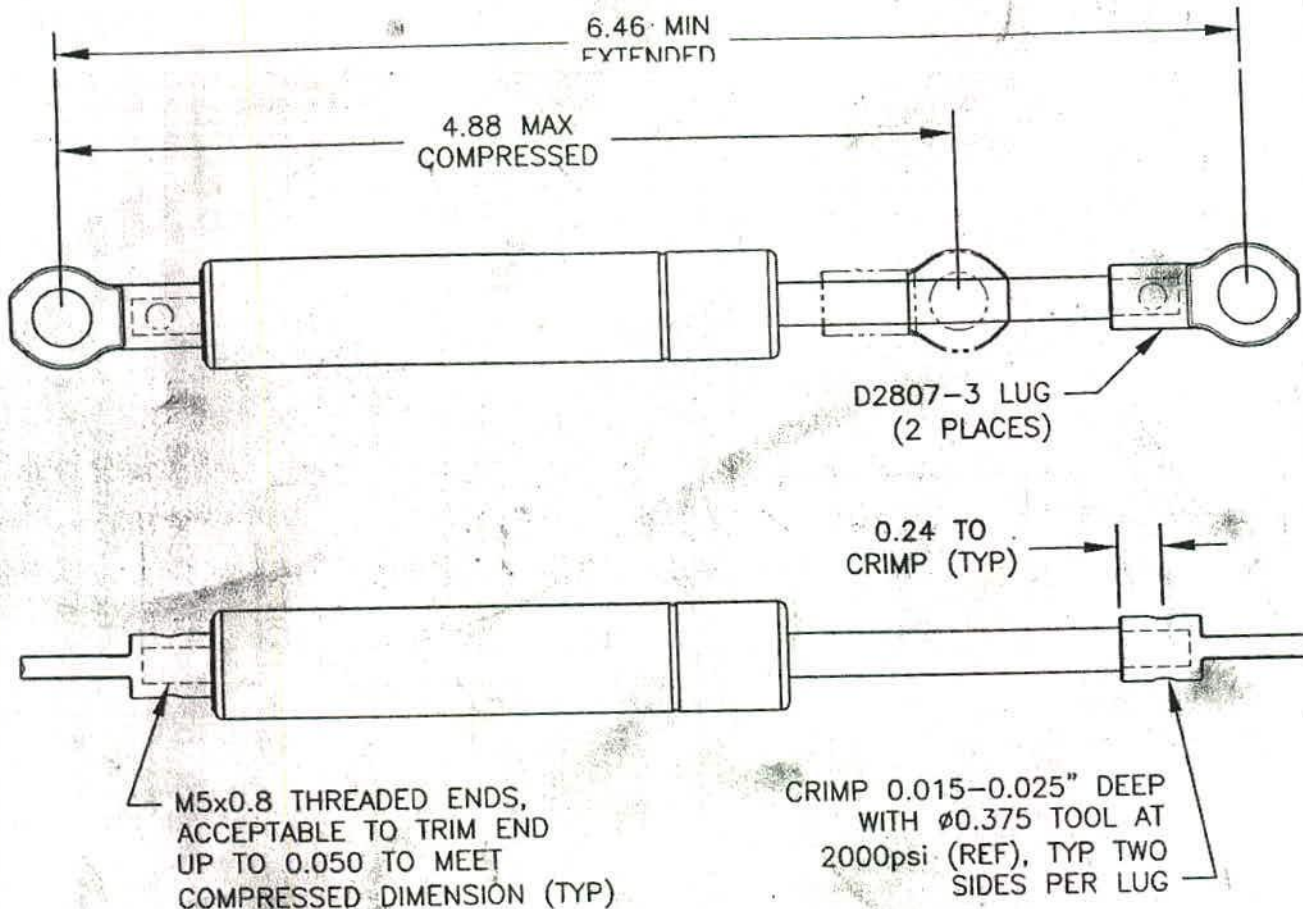
Job Completion



LC 07.11.22

DART

RELEASED
#05-06-16



| DESIGN | DRAWN BY | DART AEROSPACE LTD |
|----------|------------|---------------------------------|
| CP | CP | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. |
| 05.05.25 | 05.05.25 | D2807 |
| DATE | TITLE | SCALE |
| 05.05.25 | GAS SPRING | 1:1 |
| A | 00.11.03 | NEW ISSUE |
| B | 05.03.16 | ADD FINISH |
| C | 05.05.25 | CHANGE SPRING TO SS, ADD -3 LUG |

D2807 GAS SPRING

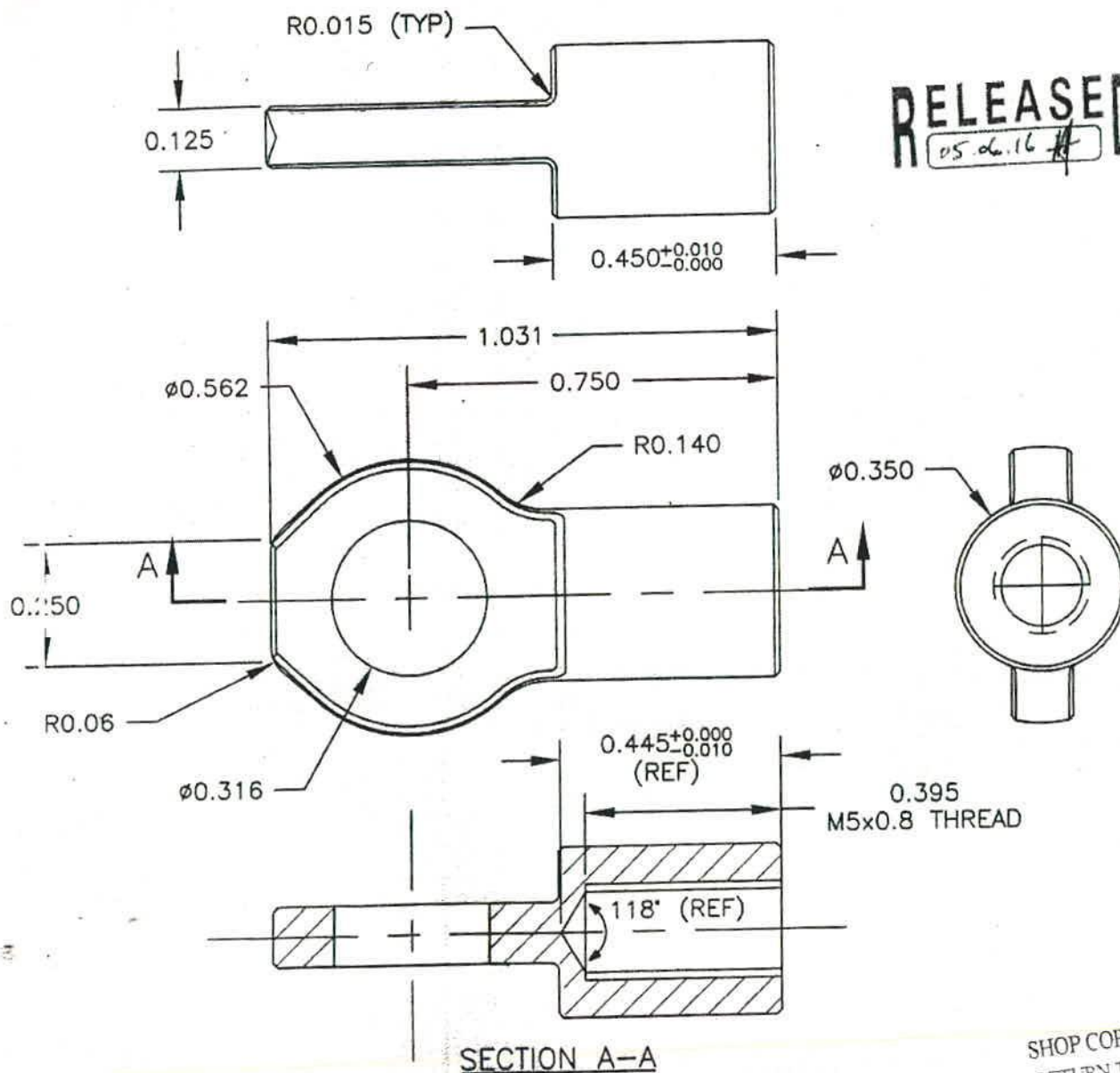
- SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2807 | REV. C SHEET 2 OF 2 |
| DATE 05.05.25 | TITLE GAS SPRING | | SCALE 3:1 |

**D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32774

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ArvinMeritor

SALES INVOICE

Invoice To:

Dart Aerospace Limited
1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7
Canada

VAT Registration Number : 738857771



FM 229

FM 229
Deliver To: If different from Invoice To address.
AS INVOICE ADDRESS

AS INVOICE ADDRESS

*** 1 CARTONS *** 3.90 kgs **
*****BTN NO 8708-9980-80 (SPRINGS)*****
Dims1@30x20x20cms

Invoice No:

61628

Date : 27/06/2007

A/C Number

2011

Customer Ref :

[illegible]

MANUFACTURED IN THE UK

Delivery Instructions:

MANUFACTURED IN THE UK

Goods Value

Net Value

VAT

| | |
|------------|--|
| Amount Due | |
|------------|--|

0.00

1275.00

ArvinMeritor

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15 New Star Road, Leicester, LE4 9JD
Fax : +44 (0) 116 274 3620
Website : www.camloc.com



INVESTOR IN PEOPLE

Light Vehicle Aftermarket

616253

INVOICE TO:

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1270 ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7
CANADA

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7 CANADA
MAIN FINISHED
GOODS

DATE _____

270407

A/C No.

20111

AREA

46

CUSTOMER REF. No.

FD 0000352A

V.A.T. REGISTRATION No. GB 738 8577 71

[illegible]

Cam 001

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